

Date: Friday, 20/02/2009 9:15:18 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
Job Number : 45922  
Estimate Number : 10531  
P.O. Number :  
This Issue : 20/02/2009 S.O. No. :  
Prsht Rev. : NC Part Number : D2572  
First Issue : / / Type : MACHINED PARTS Drawing Number : D2572 REV E  
Previous Run : 43565 Drawing Revision : E  
Material :  
Due Date : 27/02/2009 Qty: 12 Um: Each  
Written By : mf 09-02-20  
Checked & Approved By :  
Comment : Est: 1 02.10.02 Re-format: Change to Dwg Rev. D & incorporated D2572 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0

D6101005

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: 034874mf 09/02/20

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. ~~034874~~ Double check by: DJPB45922

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

mf 09/02/2489 09/02/21

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 &amp; D2572

mf 09/02/2489 09/02/23

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 09/02/2489 09/02/22

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 45922

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 09/02/26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

B/L 09-02-26 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:45

OVEN TEMPERATURE:

320°

FINISH TIME:

8:15

FL 09/03/02 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-02 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

9/3/2

12X  
Se

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



MR  
09-03-02

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 45922
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b> D2572
<b>Inspection Dwg: D2572 Rev. E</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.490	.490	.491	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.503	.505	.497		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.571	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.499	1.500	1.500	1.500		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.124	.120	.120	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.241	.243	.248		
S	0.115	0.135		.126	.120	.120	.123		
T	0.178	0.198		.188	.188	.188	.183		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.241	.235	.233	.238		
W	0.115	0.135		.130	.130	.125	.125		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.383	1.380	1.389	1.385		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.247	.247	.250	.250		
AH	0.240	0.260		.253	.250	.250	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u>SP</u>	Audited by: <u>JL</u>
Date: <u>09/02/21</u>	Date: <u>09/02/26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>45922</b>
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg: D2572 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 X	6 X	7 X	8 X		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.746	1.746	1.746		
C	3.495	3.505		3.500	3.496	3.496	3.496		
D	1.745	1.755		1.750	1.746	1.746	1.746		
E	7.990	8.010		8.000	7.999	8.000	8.000		
F	0.490	0.510		.500	.497	.504	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.503	.500	.503	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.568	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.253	.255	.253	.253		
S	0.115	0.135		.127	.134	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.962	2.962	2.963		
V	0.230	0.250		.240	.250	.245	.246		
W	0.115	0.135		.125	.125	.127	.124		
X	0.307	0.312		.310	.312	.312	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.629	.626	.629		
AC	0.053	0.073		.060	.060	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.390	1.385	1.385		
AF	0.115	0.135		.125	.125	.130	.125		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.250	.260	.255	.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.037	.033		
Accept/Reject									

Measured by: *SS*  
Date: *09/02/23* *mmv* *09/02/24*

Audited by: *JL*  
Date: *09/02/23*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 45922
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<b>Inspection Dwg: D2572 Rev. E</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 <sub>9</sub>	2 <sub>10</sub>	3 <sub>11</sub>	4 <sub>12</sub>	By	Date
A	0.438	0.443		.440	.439	.439	.440		
B	1.745	1.755		1.747	1.747	1.748	1.747		
C	3.495	3.505		3.499	3.500	3.505	3.502		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		7.998	8.000	8.000	7.997		
F	0.490	0.510		.509	.508	.510	.510		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.376	.375	.375		
I	0.490	0.510		.503	.504	.507	.500		
J	1.174	1.184		1.179	1.179	1.178	1.179		
K	0.558	0.578		.573	.573	.575	.573		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.496		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	3.869	3.879		3.870	3.874	3.870	3.871		
P	0.115	0.135		.129	.126	.125	.127		
Q	0.115	0.135		.130	.130	.127	.130		
R	0.240	0.260		.255	.255	.256	.254		
S	0.115	0.135		.126	.126	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.959	2.961		
V	0.230	0.250		.250	.247	.243	.245		
W	0.115	0.135		.126	.121	.125	.125		
X	0.307	0.312		.310	.312	.312	.312		
Y	0.760	0.765		.762	.760	.760	.761		
Z	0.352	0.372		.360	.362	.363	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.386	1.385		
AF	0.115	0.135		.135	.130	.133	.130		
AG	0.240	0.280		.245	.255	.246	.250		
AH	0.240	0.260		.260	.255	.256	.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	2.000	2.000		
Accept/Reject									

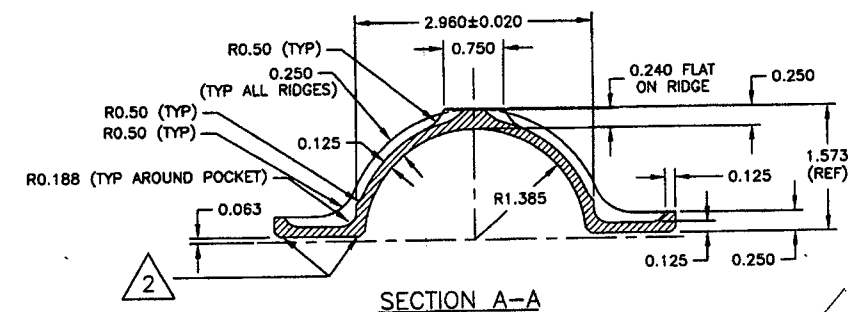
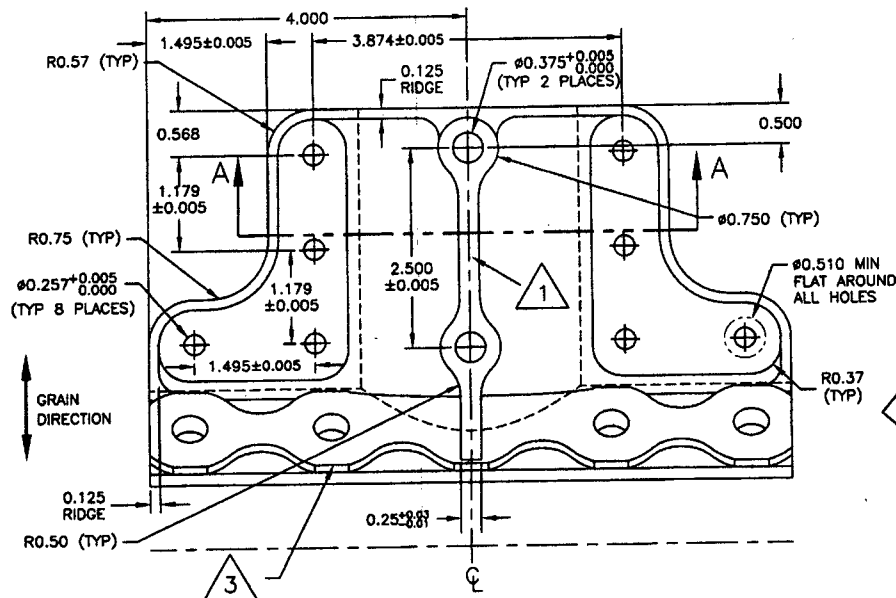
Measured by: <u>                    </u>
Date: <u>09/02/25</u>

Audited by: <u>                    </u>
Date: <u>09/02/26</u>

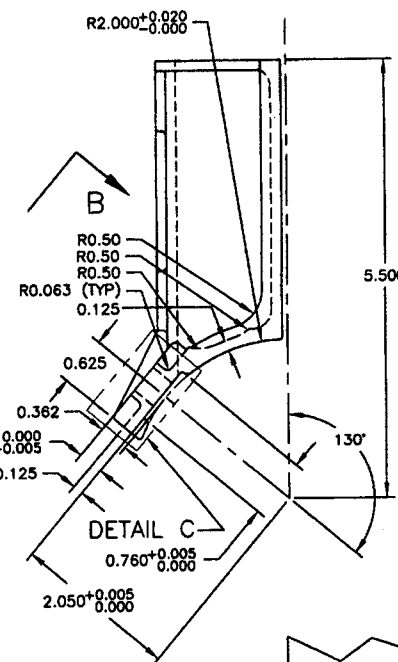
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

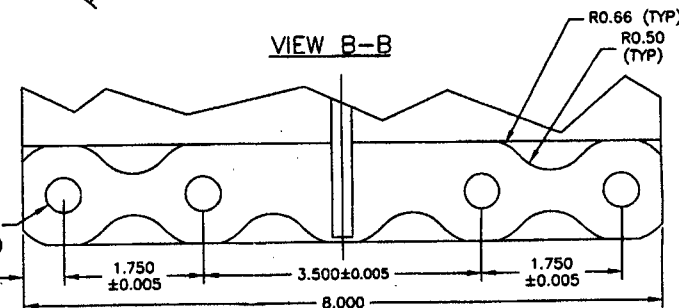
05.12.06



SECTION A-A



DETAIL C



VIEW B-B

# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE INNER FWD SADDLE
		DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E
		SHEET 1 OF 1
		SCALE 2:1

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206517012

DETAIL C  
SCALE 2:1